

Date: Wednesday, 5/16/2007 1:42:33 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	32411	Part Number	D353523
Estimate Number	12740	Drawing Number	D3535-UNDER REVIEW
P.O. Number	N/A	Project Number	N/A
This Issue	5/16/2007	Drawing Revision	A B C D
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	5/31/2007
Previous Run	30760	Qty:	16
Written By		Um:	Each
Checked & Approved By	<u>07.05.16</u>		
Comment	Est Rev:A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 1.4296 sf(s)/Unit Total : 22.8732 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <u>A101 873</u> <u>SAD 07/05/26</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 07/05/21</u> <u>ZG</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SAD 07.05.31</u> <u>ZG</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:42:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32411

Part Number: D353523

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



coated
X-26

Comment: INSPECT WORK TO CURRENT STEP

FL 07/06/21

7.0 POWDER COATING

POWDER COATING



M101601



Q6X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-d 07/06/22

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/25

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Q6X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P-18

m-f

07/06/25

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Q6

Comment: FINAL INSPECTION/W/O RELEASE

FL 07/06/26

Job Completion



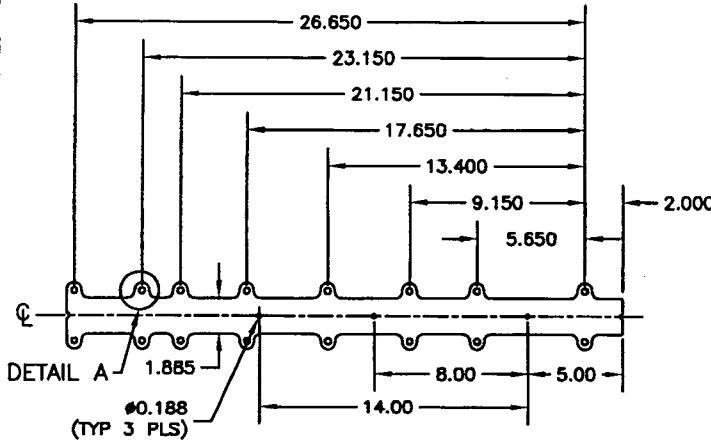
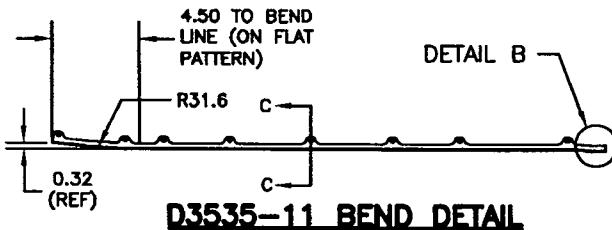
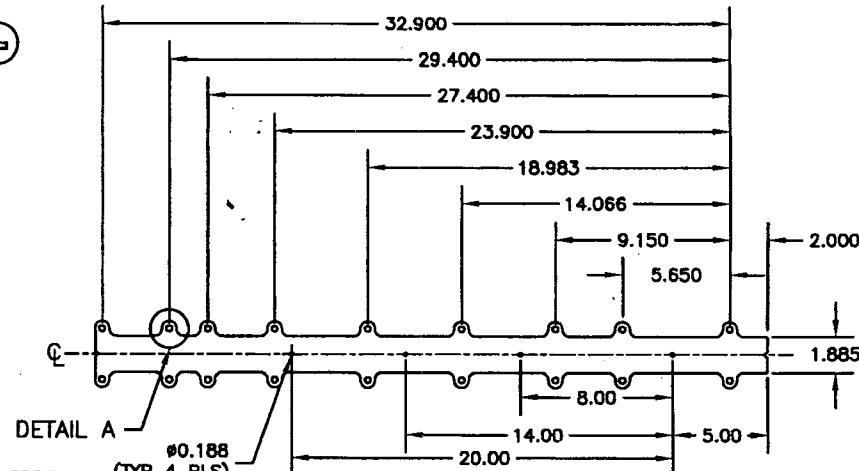
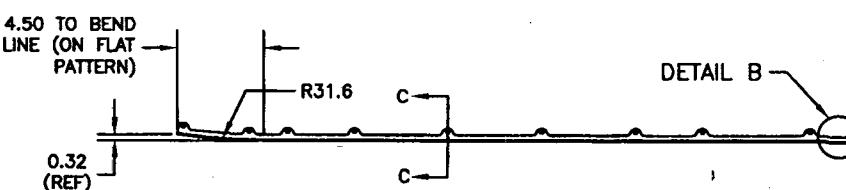
FL 07/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
7/04/17	7/04/17	D3535
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 3241

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

NO. 32411

4.50 TO BEND
LINE (ON FLAT
PATTERN)

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DETAIL A

$\#0.188$
(TYP 4 PLS)

D3535-15F FLAT PATTERN

0.32 (REF)

4.50

TO BEND
LINE

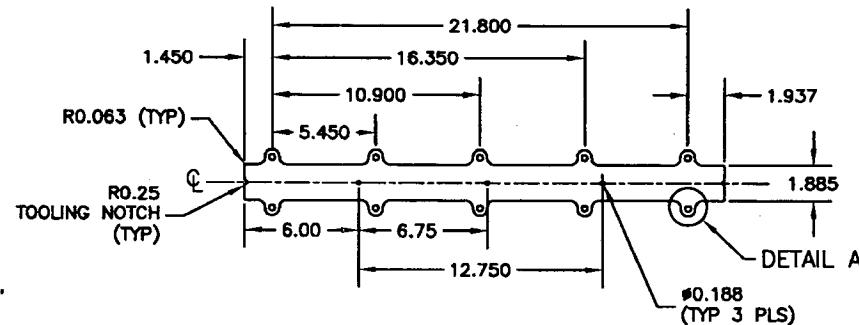
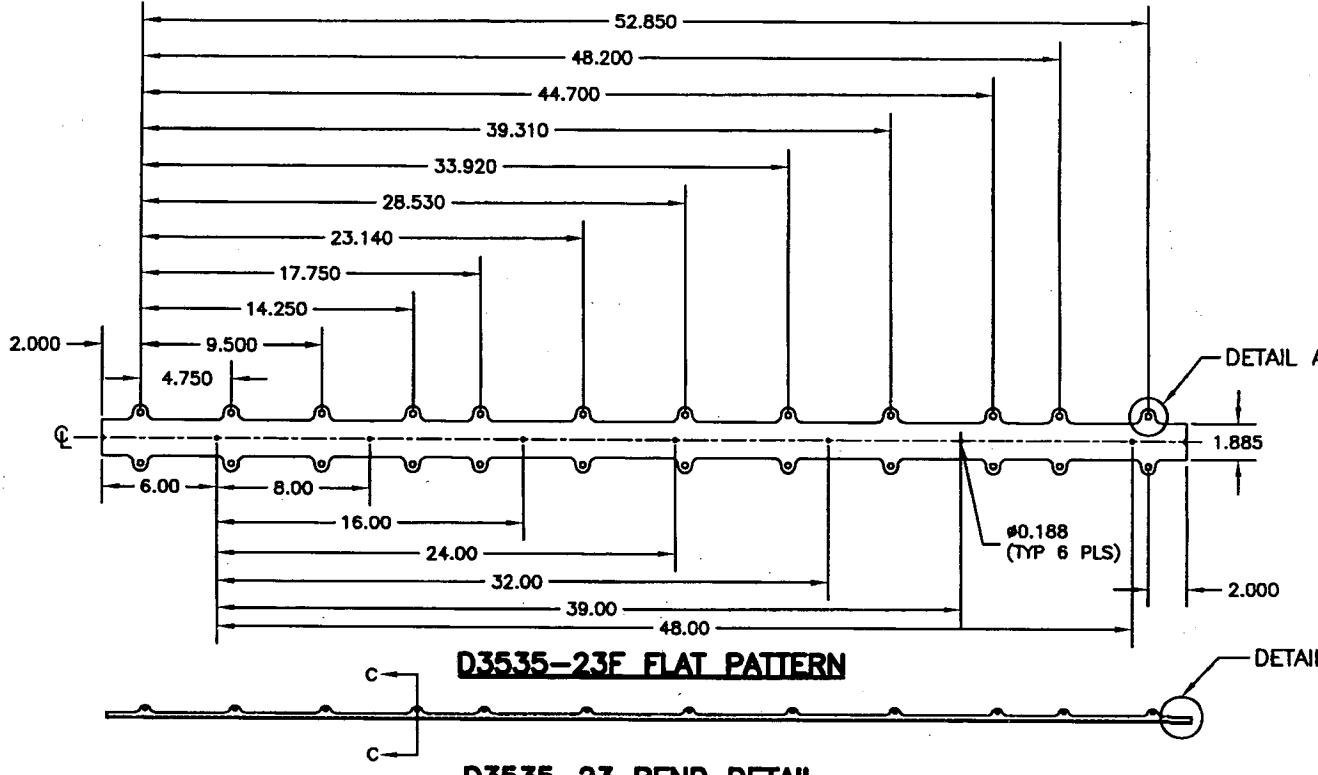
(ON FLAT
PATTERN)

4.50

DART

RELEASED

07.04.24

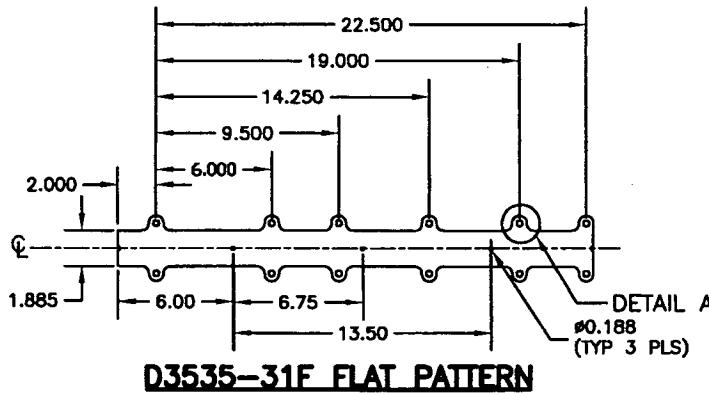


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NOTES

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

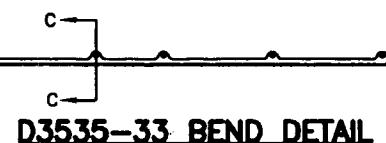
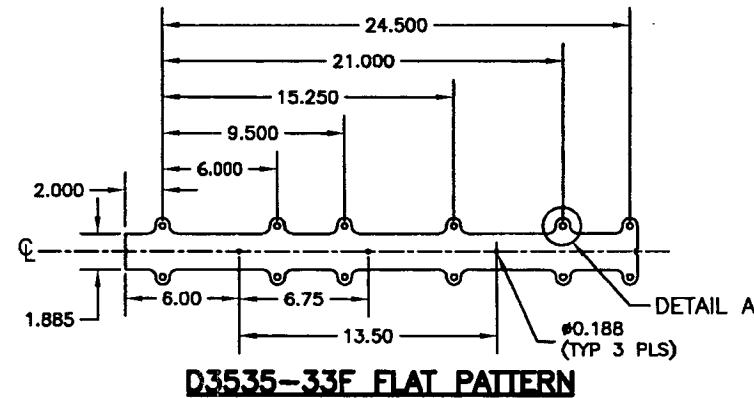
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<u>PH</u>	<u>PH</u>	D3535
DATE		SCALE
07.04.17		1:10

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07.04.17DETAIL A
#0.188
(TYP 3 PLS)**D3535-31 BEND DETAIL**

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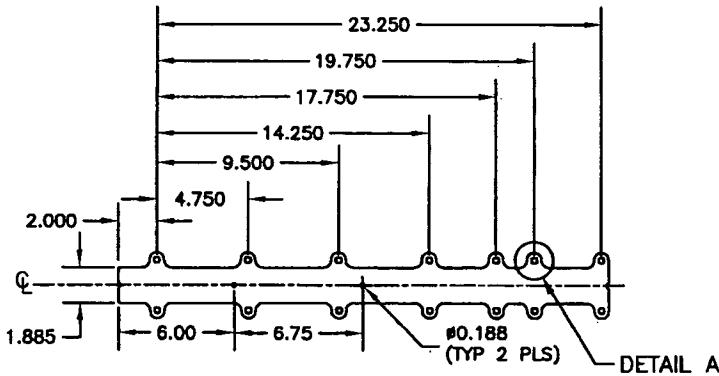
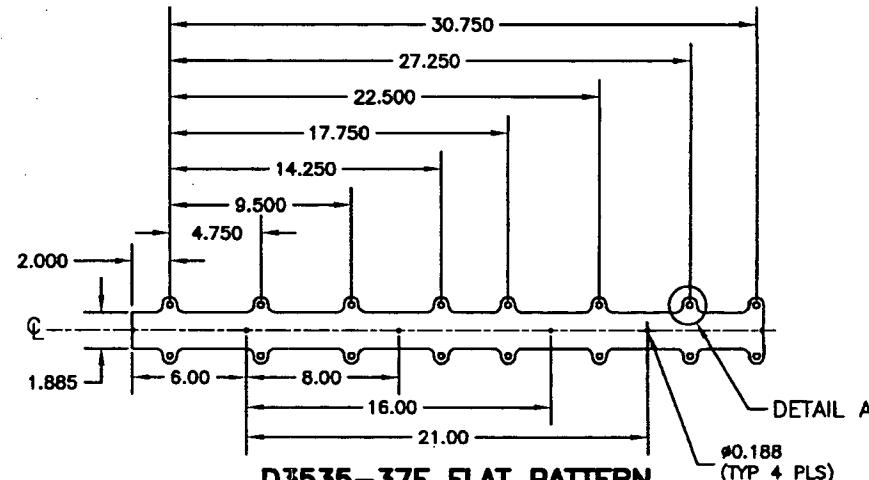
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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DATE 07.04.17		SCALE 1:10

REV. B
SHEET 4 OF 7

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07.04.24**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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		D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B		SHEET 5 OF 7
		SCALE
		1:10

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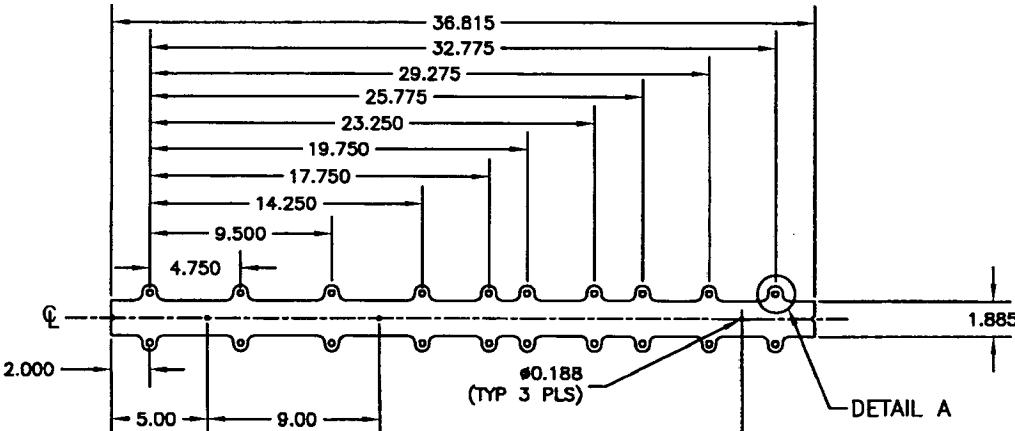
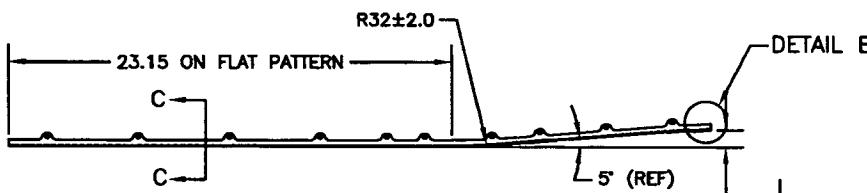
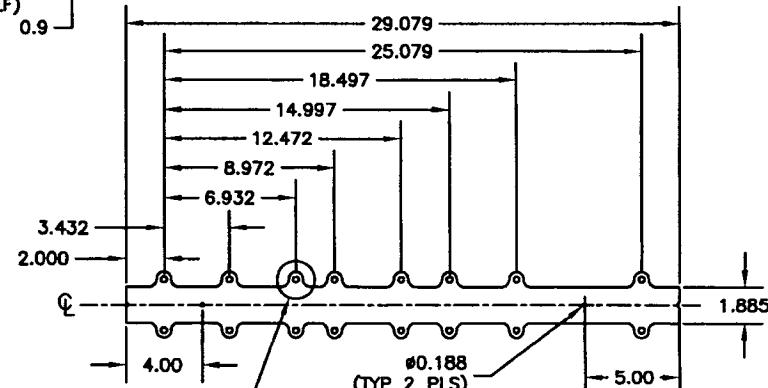
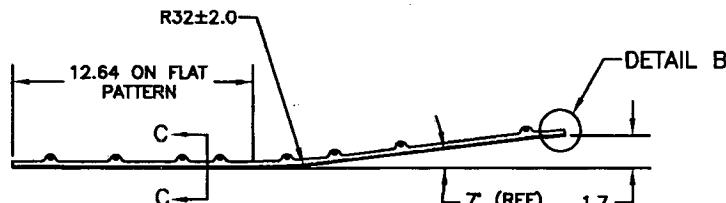
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07.04.17	PH	D3535
DATE		TITLE
		WEARSHOE

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07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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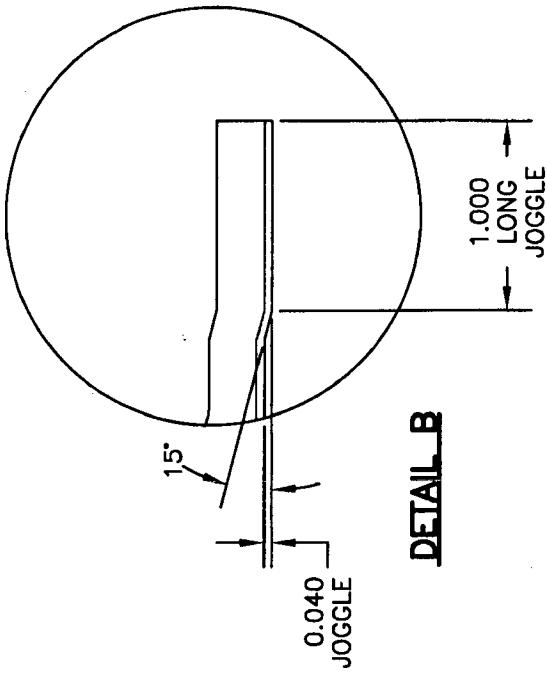
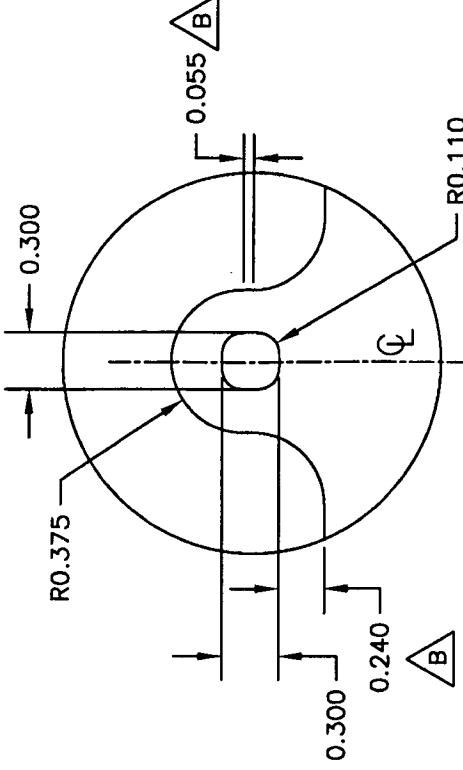
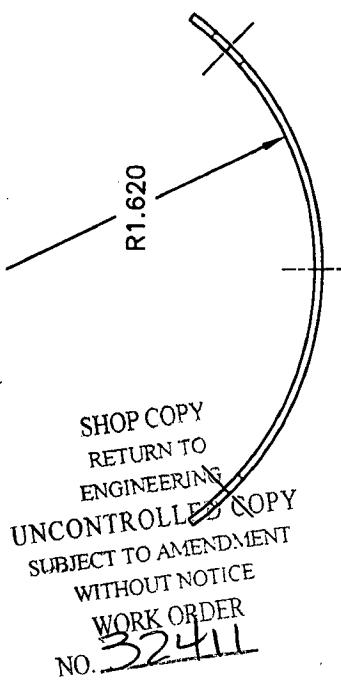
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- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17		REV. B SHEET 7 OF 7 TITLE WEARSHOE SCALE 1:1

RELEASED

07.04.24 *[Signature]***DETAIL B****DETAIL A****SECTION C-C**

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NO. *32411*

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DART AEROSPACE LTD

Work Order: 32411

Description: WEAR SHOE

Part Number: D353523

Inspection Dwg: D3535 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 52.850	+/- 0.010	52.850	✓	—	M-T	
B 48.200	+/- 0.010	48.200	—	—	M-T	
C 44.700	+/- 0.010	44.700	✓	—	M-T	
D 39.310	+/- 0.010	39.310	—	—	M-T	
E 33.920	+/- 0.010	33.920	—	—	M-T	
F 28.530	+/- 0.010	28.530	—	—	Vern / M-T	
G 23.140	+/- 0.010	23.140	✓	—	M-T	
H 17.750	+/- 0.010	17.750	—	—	M-T	
I 14.250	+/- 0.010	14.250	✓	—	M-T	
J 9.500	+/- 0.010	9.500	—	—	Vern	
K 4.750	+/- 0.010	4.753	—	—	Vern	
L 2.000	+/- 0.010	2.000	—	—	Vern	
M 6.00	+/- 0.030	6.00	✓	—	Vern	
N 8.00	+/- 0.030	8.61	✓	—	Vern	
O 16.00	+/- 0.030	16.61	✓	—	Vern / M-T	
P 24.00	+/- 0.030	24.01	✓	—	Vern / M-T	
Q 32.00	+/- 0.030	32.00	✓	—	Vern / M-T	
R 39.00	+/- 0.030	39.00	—	—	Vern / M-T	
S 48.00	+/- 0.030	48.00	✓	—	Vern / M-T	
T 1.885	+/- 0.010	1.891	✓	—	Vern	
U 0.300	+/- 0.010	0.300	—	—	Vern	
V 0.300	+/- 0.010	0.297	—	—	Vern	
W 6.038	+/- 0.010	6.036	✓	—	Vern	
X						
Y						

Measured by:	SAD
Date:	07/05/21

Audited by:	SC
Date:	07/05/21 07/05/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	